

Work Order ID 131458

Thursday, April 09, 2015 11:43:02 AM

131458

RH door

Page 1

Item ID: D4484-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bottom Panel Assembly, RH

Start Date: 4/9/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/22/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: mfDate: 15-4-9

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4484	REV C								

100

0.00

100

FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg (D4484-1F)

Dwg Rev: CProg Rev: C

2-Deburr if necessary

①

12/15/04/10

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

①

12/15/04/10

Work Order ID 131458

Thursday, April 09, 2015 11:43:02 AM

131458

Page 3

Item ID: D4484-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

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Item Name: Bottom Panel Assembly, RH

Start Date: 4/9/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/22/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00				1		15-4-22	DGC
160									
HandFinish	Memo	0.00							
Hand Finishing									
165	QC7-Inspect Chemical Conversion Coat	0.00				1			CA 1504-27
165									
QC	Memo	0.00							
Quality Control									
166		0.00							
166									
SprayPaint	Memo	0.00				1			DAS 41 9-88
Spray Painting	Prime tempo grey as per dwg (note 2, sheet 2) Batch: 131846							15-4-28	

Work Order ID 131458***131458***

Page 5

Thursday, April 09, 2015 11:43:02 AM

Item ID: D4484-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bottom Panel Assembly, RH

Start Date: 4/9/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/22/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

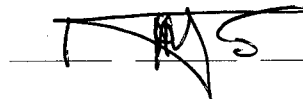
190

Identify as per dwg & Stock Location: 5T-234 0.00***190***

Packaging

Memo

0.00

D:
G:
9-89

APR 30 2015

Packaging

200

QC21 - Final Inspection - Work Order Release 0.00

200

QC

Memo

0.00

MCS

MAY 04 2015

Quality Control



Picklist Print

Thursday, April 09, 2015 11:43:01 AM

Page 1

Work Order ID: 131458

131458

Parent Item: D4484-042

D4484-042

Parent Item Name: Bottom Panel Assembly, RH

Start Date: 4/9/2015

Required Date: 4/22/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.12.04 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4484-5		Manufactured	No				Each	14.0000		3			
D4484-5									**			15/04/29	DAS 36 9-89
Nutplate Retainer													

Location

Loc Qty

Loc Code

MF

14

103646

3

86321

1

98154

10

Each

4,975.000

6

DAS
36
9-89

Location

Loc Qty

Loc Code

CA

12

125578

12

GA

3983

m131697

3983

MF4

19

125578

19

ST313

961

m127432

961

Each

699.0000

6

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

495

125445

495

ST312

204

125445

204

MS20426AD3-4

Purchased

No

MS20426AD3-4

RIVET

M 131624
OX

MS20426AD4-4

Purchased

No

MS20426AD4-4

Rivet

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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OTHER :																																																																							

Picklist Print

Thursday, April 09, 2015 11:43:01 AM

Page 2

Work Order ID: 131458

Parent Item: D4484-042

Parent Item Name: Bottom Panel Assembly, RH

131458

D4484-042

Start Date: 4/9/2015

Required Date: 4/22/2015

Start Qty: 1.00

Required Qty: 1.00

MS21059L08

Purchased

No

Each

485.0000

3

MS21059L 08

Nut

**

DAS

36

9-89

15/04/29

Location

Loc Qty

Loc Code

MF4

74

125654

74

ST260a

200

m131697

200

ST302

211

m131317

11

m131624

200

3

M6061T6S.063

Purchased

No

100

sf

258.9863

1.29

2

M6061T6S 063

6061-T6 .063 Sheet

**

DL15/04/10

Location

Loc Qty

Loc Code

MAT

59.25

M131653

59.25

MAT021

199.7363

M128941

11.132

M129845

29.7743

M130096

25

M131322

85.83

M131383

48

131653

1.6

DQA: _____ Date: _____



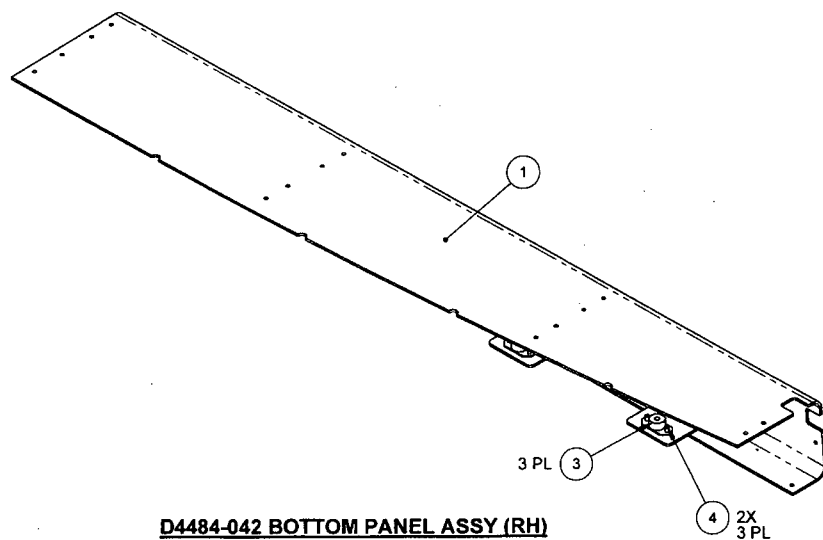
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

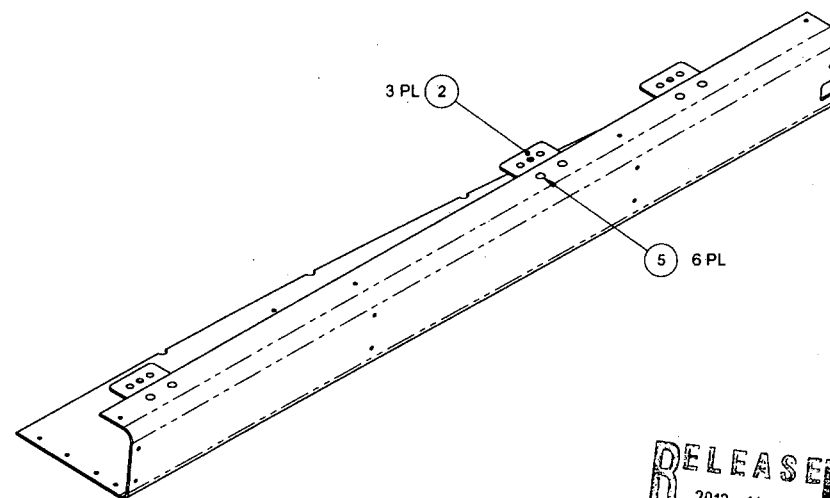
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

ITEM	QTY	P/N	DESCRIPTION
	X	D4482-042	BOTTOM PANEL ASSY (LH)
1	1	D4484-2	BOTTOM PANEL (RH)
2	3	D4484-5	NUTPLATE RETAINER
3	3	MS21059L08	NUTPLATE
4	6	MS20426AD3-4	RIVET, CSK
5	6	MS20426AD4-4	RIVET, CSK



D4484-042 BOTTOM PANEL ASSY (RH)



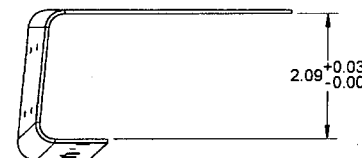
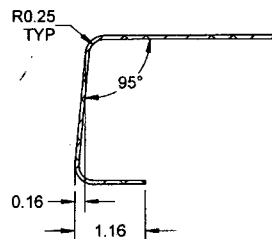
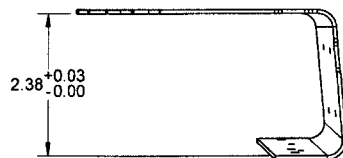
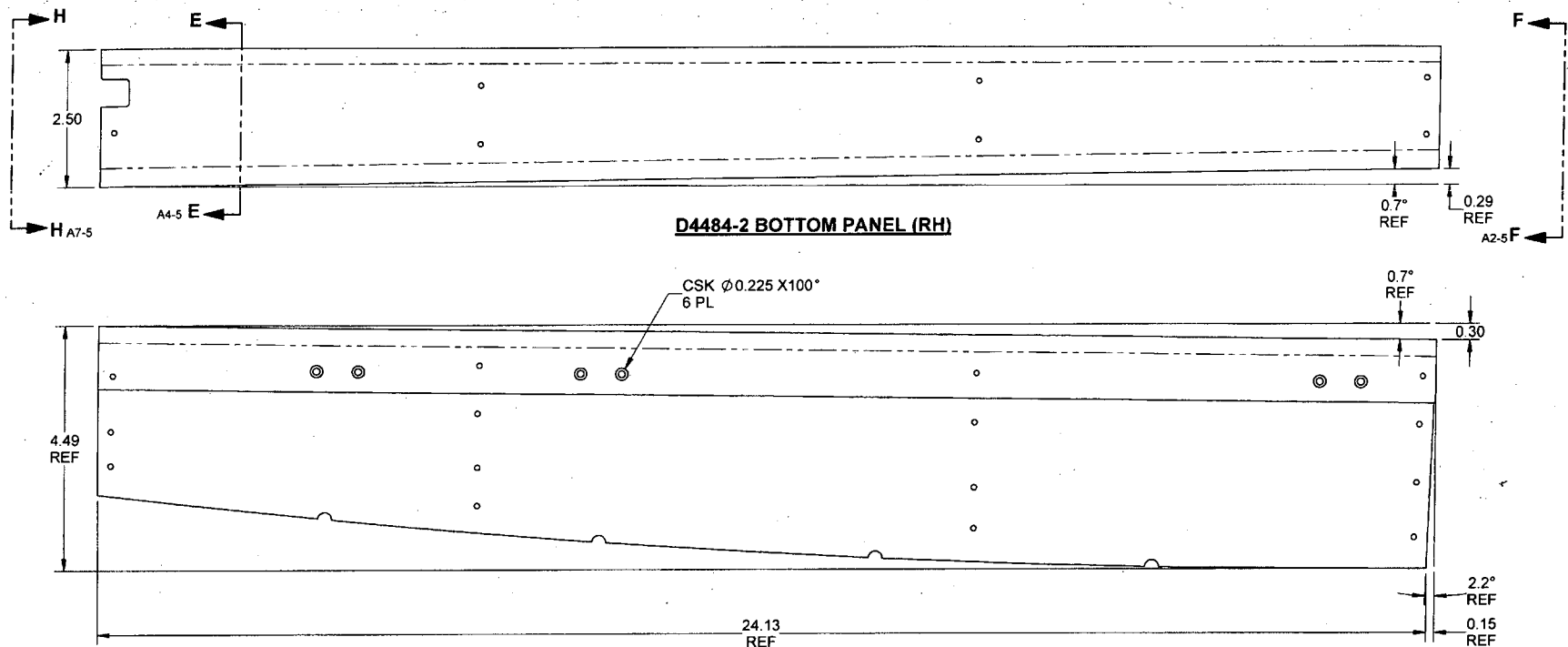
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.09 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. C
MFG. APPR.	18	D4484	SHEET 4 OF 8
APPROVED	19	TITLE	SCALE
DE APPR.	19	BOTTOM PANEL ASSY	NTS
DATE	12.10.08	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

mf
11/31/08

RELEASED
2012-11-29
mf



- NOTES:**
- 1) MATERIAL: MAKE FROM D4484-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.02 lbs

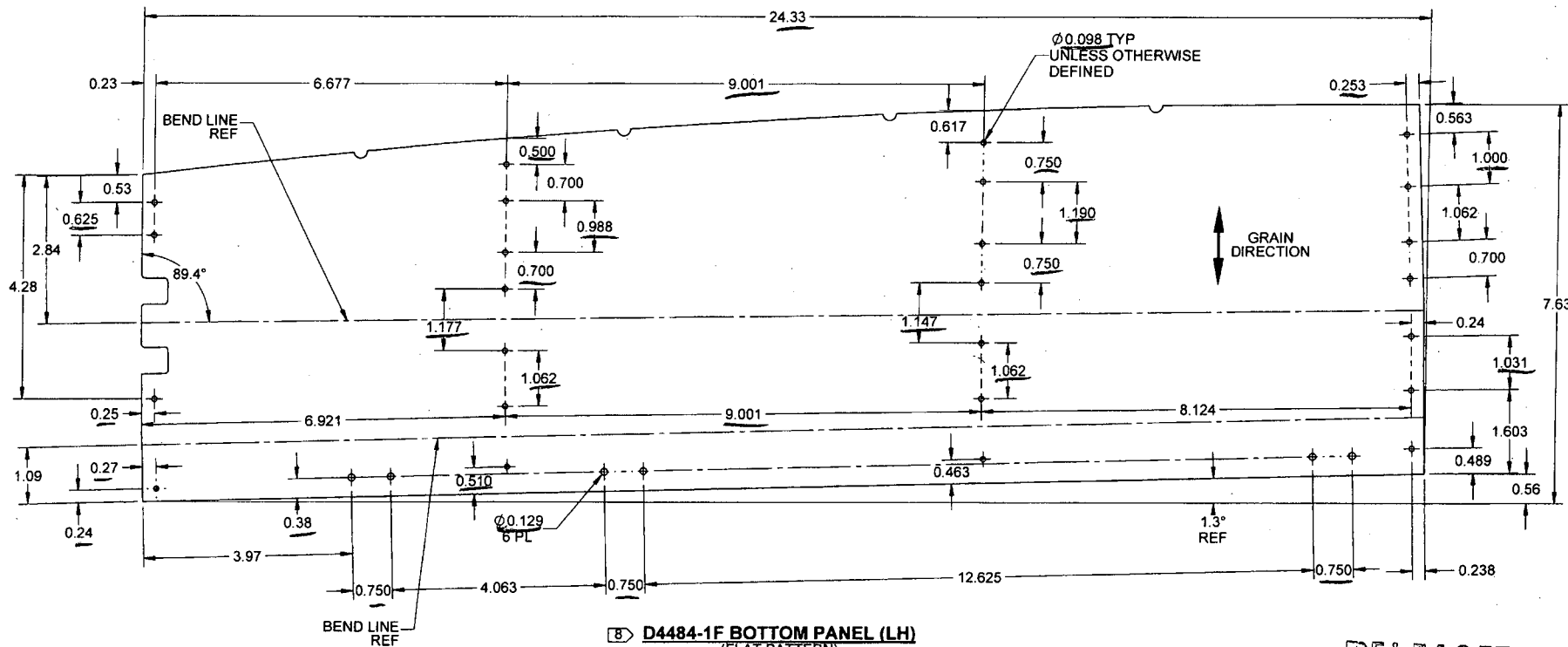
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JS	D4484	SHEET 5 OF 8
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BOTTOM PANEL ASSY	NTS
DATE	12.10.08	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

2.2/8

RELEASED
2012-11-29

8 7 6 5 4 3 2 1

131458



8 D4484-1F BOTTOM PANEL (LH)
(FLAT PATTERN)

RELEASED
2012-11-29
mp

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.02 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILES "D4484-1F-REV.C.DXF"

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JS	D4484	SHEET 7 OF 8
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BOTTOM PANEL ASSY	NTS
DATE	12.10.08	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DART AEROSPACE LTD		Work Order:	131458
Description: Bottom panel		Part Number:	4489-092
Inspection Dwg: 4484 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.25	$\pm .030$	.250	/		VzDm-01	
.27	$\pm .030$	.267	/		VzDm-02	
.24	$\pm .030$	.246	/		Tape	
.38	$\pm .030$	.384	/			
.510	$\pm .010$	.515	/			
.750	$\pm .010$	.752	/			
.625	$\pm .010$	.628	/			
1.062	$\pm .010$	1.066	/			
1.177	$\pm .010$	1.179	/			
.700	$\pm .010$	.702	/			
.988	$\pm .010$	.990	/			
.500	$\pm .010$	.497	/			
1.190	$\pm .010$	1.192	/			
1.147	$\pm .010$	1.150	/			
1.000	$\pm .010$	1.001	/			
1.031	$\pm .010$	1.033	/			
9.001	$\pm .010$	9.002	/			
.253	$\pm .030$	.254	/			
24.33	$\pm .030$	24.33	/			
$\emptyset .129$	$-.001 + .005$	$\emptyset .129$	/			
$\emptyset .098$	$-.001 + .004$	$\emptyset .098$	/			

Measured by: DL	Audited by: 9-89	Preliminary Approval:
Date: 15/04/10	Date: APR 13 2015	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	